

Date:

Wednesday, 10/31/2007 3:26:40 PM

User:

Kim Johnston

Process Sheet

48

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CONSOLE ASSEMBLY 407
Job Number	: 35491		
Estimate Number	: 11720		
P.O. Number	: <i>N/A</i>	Part Number	: D407547047
This Issue	: 10/31/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D206-547 REV F
Prsht Rev.	: <i>NO</i>	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: F
Previous Run	: 34744	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 11/26/2007 Qty: 6 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev: 06-01-05 Removed Packing Kit JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2024	Extrusion, Console
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Comment: Qty.: 3.5910 Each(s)/Unit Total : 21.5460 Each(s)
 D2024 Extrusion
 Batch *M1*

FF 07-01-14 (6)

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT
 8264-1, DT 8264-2, DT8264-3, DT8264-4

2-Debur

FF 07-11-14 (6)

3.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

4.0	D26041	407 Hi Console Side LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Pick:

Qty	Part Number	Description	Batch
1	D2604-1	Side LH	<i>B34778</i>

FF 07-11-14 (6)

5.0	D26042	407 Hi Console Side RH
-----	--------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Pick:

Qty	Part Number	Description	Batch
1	D2604-2	Side RH	<i>B34779</i>

FF 07-11-14 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY 407

Job Number: 35491

Part Number: D407547047

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2606

Hi Console Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2606

Bracket

B 33908

FF

07-11-14

6

7.0

D2608

407 Console Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2608

Bracket

B 17357

FF

07-11-14

6

8.0

MS20470AD33

Rivet, Universal Head



Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

6 MS20470AD3-3

Rivet

M 1065

FF

07-11-14

6

9.0

MS20470AD34

Rivet, Universal Head



Comment: Qty.: 20.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

20 MS20470AD3-4

Rivet

M 15541

FF

07-11-14

6

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Grind weld relief chamfer as per Dwg D206-547

2-Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4

FF

07-11-14

6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/31/2007 3:26:40 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY 407

Job Number: 35491

Part Number: D407547047

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07-11-14 (6)

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D206-547

A/R AL ROD Batch: 105098

2-Grind weld as per dwg D206-547

FC 07 11 15

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-11-16 (6)

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3

FF 07-11-29

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-11-30 (X6)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

07-12-03 (X6)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-12-04 (6)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST220

AS 07/12/04

(X6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 01/12/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/31/2007 3:26:40 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY 407

Job Number: 35491

Part Number: D407547047

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

12/01/06

Job Completion



U 07.12.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED KE	DRAWING NO. D206-547	REV. F SHEET 1 OF 5
DATE 99.02.11		TITLE CONSOLE ASSEMBLY	SCALE NTS
-	82.11.23	NEW ISSUE	
A	83.01.18	REDRAWN, ADD NOTE 4	
B	84.10.23	D206-547 WAS 01.B.81.017	
C	89.03.30	REDRAWN	
D	90.12.06	COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85	
E	97.10.22	REDRAWN, ADD -043,-045,-047	
F	99.02.11	ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL	

RELEASED
99.03.05 RE

-041	-043	-045	-047	PART NUMBER	DESCRIPTION
X				D206-547-041	CONSOLE ASSEMBLY
	X			D206-547-043	CONSOLE ASSEMBLY
		X		D407-547-045	CONSOLE ASSEMBLY
			X	D407-547-047	CONSOLE ASSEMBLY
1				D2601-1	CONSOLE SIDE
1				D2601-2	CONSOLE SIDE
	1			D2602-1	CONSOLE SIDE
	1			D2602-2	CONSOLE SIDE
		1		D2603-1	CONSOLE SIDE
		1		D2603-2	CONSOLE SIDE
			1	D2604-1	CONSOLE SIDE
			1	D2604-2	CONSOLE SIDE
1		1		D2605	CONSOLE BRACKET
	1		1	D2606	CONSOLE BRACKET
1	1			D2607	CONSOLE BRACKET
		1	1	D2608	CONSOLE BRACKET
1		1		D2709-1	CONSOLE SIDE RAIL
1		1		D2709-2	CONSOLE SIDE RAIL
1		1		D2709-3	CONSOLE SIDE RAIL
1		1		D2709-4	CONSOLE SIDE RAIL
	1		1	D2710-1	CONSOLE SIDE RAIL
	1		1	D2710-2	CONSOLE SIDE RAIL
	1		1	D2710-3	CONSOLE SIDE RAIL
	1		1	D2710-4	CONSOLE SIDE RAIL
10	8	8	6	MS20470AD3-3	RIVET
18	20	18	20	MS20470AD3-4	RIVET

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WITHOUT NOTICE
WORK ORDER
NO. 35491

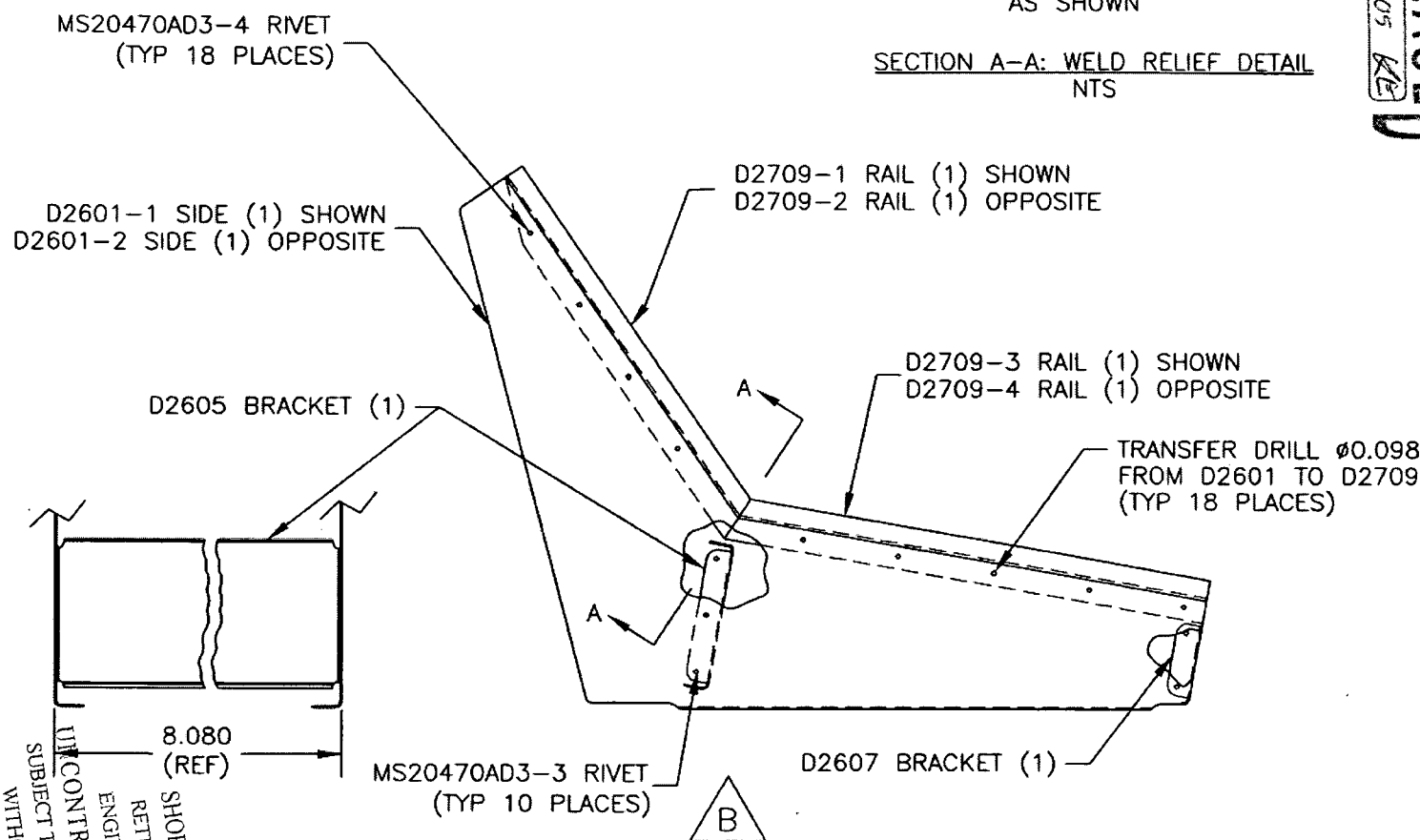
DART

RELEASED
99.03.05 KE



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D206-547-041 (206 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

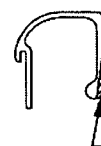
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CHECKED	CP	APPROVED	KE	
DATE	99.02.11	TITLE	D206-547	REV. F
			CONSOLE ASSEMBLY	SHEET 2 OF 5
				SCALE 1:4

NO
WORK ORDER
35491
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UNCONTROLLED
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SHOP COPY
35491

DART

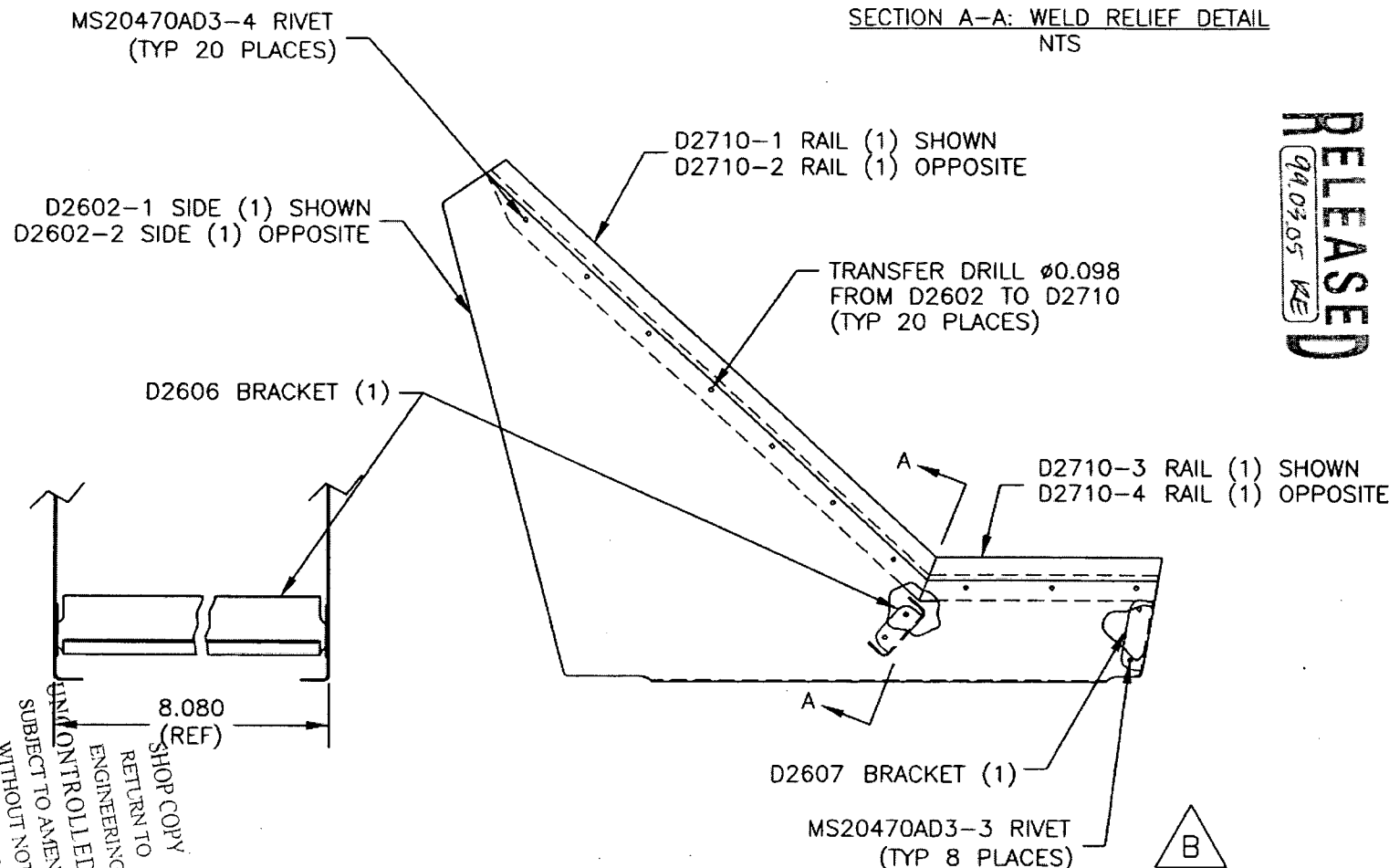
RELEASED
99.03.05 KE

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CHECKED UP	APPROVED KE	DRAWING NO. D206-547
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	REV. F SHEET 3 OF 5
		SCALE 1:4



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

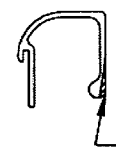
SECTION A-A: WELD RELIEF DETAIL
NTS



D206-547-043 (206 HIGH SLOPE CONSOLE)

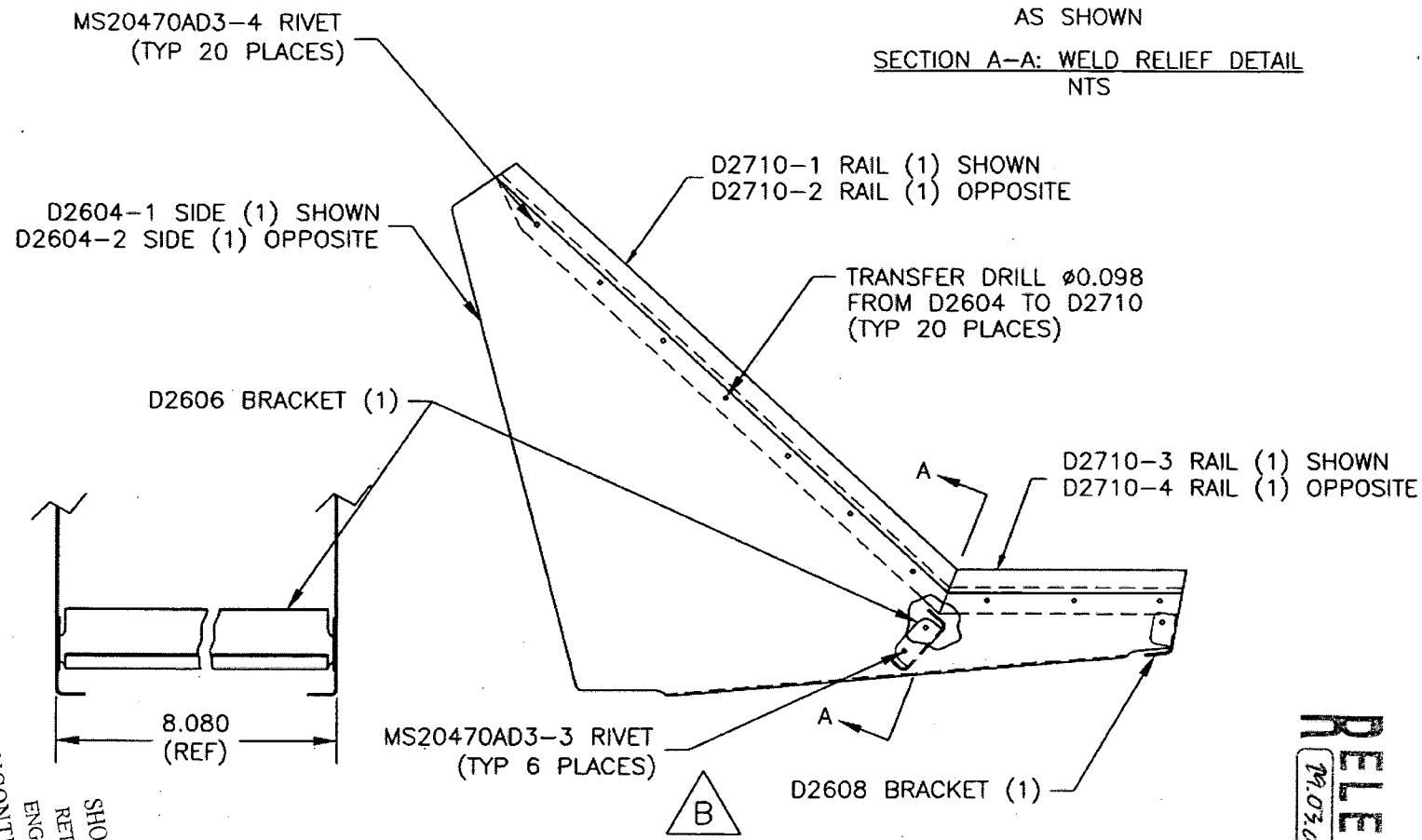
FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 354291
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GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
190305 KE

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BW	RF	
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KE	KE	D206-547
DATE	TITLE	REV. F
99.02.11	CONSOLE ASSEMBLY	SHEET 5 OF 5
		SCALE 1:4

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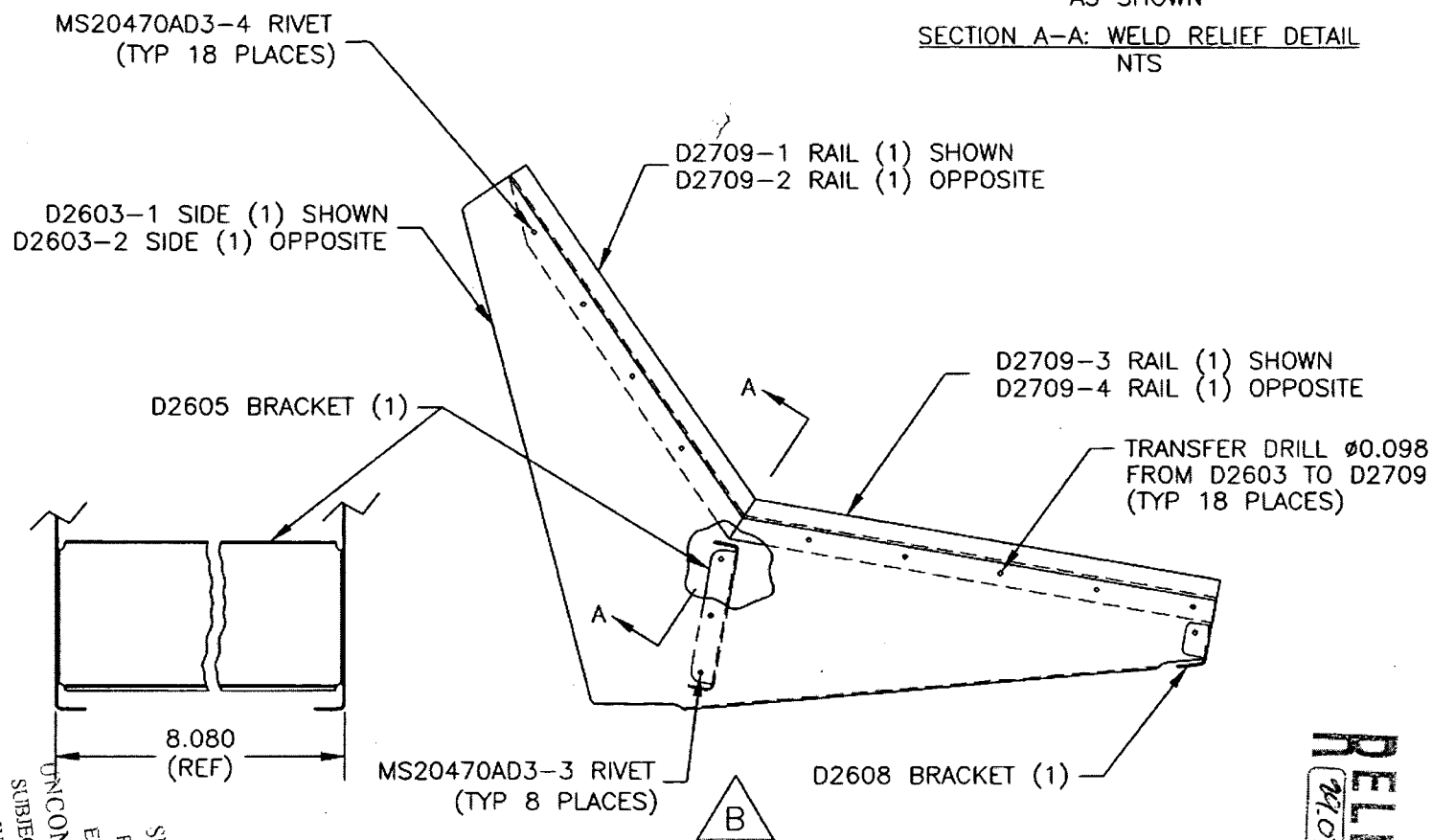
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WORK ORDER

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GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-045 (407 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
210305 RE

DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWESBURY, ONTARIO, CANADA	REV. F
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D206-547	SHEET 4 OF 5
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	SCALE 1:4	

NO. 35291
WORK ORDER
35291
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